

# Work Order ID 81682

**\*81682\***

Page 1

Friday, March 16, 2012 1:54:41 PM

Item ID: D3783-045\

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Angle Brace Assembly

Start Date: 3/29/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 3/29/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Run Start **\*NR1\***

Approvals:

Process Plan: *[Signature]*

Date: *12-23-16*

Tooling:

Date:

Stop **\*NR2\***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3783	Rev A

100	Pick Kit	0.00							
-----	----------	------	--	--	--	--	--	--	--

**\*100\***

Packaging

Memo

Packaging

110	Small Fab	0.00							
-----	-----------	------	--	--	--	--	--	--	--

**\*110\***

Small Fab

Memo

Small Fab

1-assemble as per dwg D3783

120	QC5- Inspect part completeness to step on W/O	0.00							
-----	---	------	--	--	--	--	--	--	--

**\*120\***

QC

Memo

Quality Control

*FF*  
*12-04-25*

*FF*  
*12-04-25*

*88*  
*12/04/25*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 81682****\*81682\***

Page 2

Friday, March 16, 2012 1:54:41 PM

Item ID: D3783-045

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Angle Brace Assembly

Start Date: 3/29/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 3/29/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

Identify as per dwg & Stock Location: 249A

0.00

**\*130\***

Packaging

Memo

0.00

Packaging

4 12/04/27

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

12/4/3012/04/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, March 16, 2012 1:54:46 PM

Page 1

Work Order ID: 81682

\*81682\*

Parent Item: D3783-045

\*D3783-045\*

Parent Item Name: Angle Brace Assembly

Start Date: 3/29/2012

Required Date: 3/29/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-05-19 new issue DD verified by:ec  
IPP Rev:B 08-06-17 rev.A as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN5-13A		Purchased	No			110	Each	60.0000	2	8			
<b>*AN5-13A*</b>													
Bolt													

Location	Loc Qty	Loc Code
----------	---------	----------

GA	20	
116003	20	
ST338	40	
118983	40	

AN960JD516	NAS1149D0563J	Purchased	No			110	Each	0.0000	4	16			
<b>*AN960JD516*</b>													

Washer													
D3765-1		Manufactured	No			110	Each	2.0000	2	8			
<b>*D3765-1*</b>													
Clevis													

Location	Loc Qty	Loc Code
----------	---------	----------

ST243	2	
75028	2	

D3769-5		Manufactured	No			110	Each	6.0000	1	4			
<b>*D3769-5*</b>													
Tube													

Location	Loc Qty	Loc Code
----------	---------	----------

ST248	2	
54345	2	
ST251	4	
80432	4	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 2

Friday, March 16, 2012 1:54:46 PM

Work Order ID: 81682

\*81682\*

Parent Item: D3783-045

\*D3783-045\*

Parent Item Name: Angle Brace Assembly

Start Date: 3/29/2012

Required Date: 3/29/2012

Start Qty: 4.00

Required Qty: 4.00

MS21042L5

Purchased

No

110

Each

1,598.000

2

8

\*MS21042L5\*

\*\*

(4) FF 12-04-25

Nut

Location

Loc Qty

Loc Code

ST300

1598

116105

5

116548

43

117611

42

118179

8

119109

1500

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

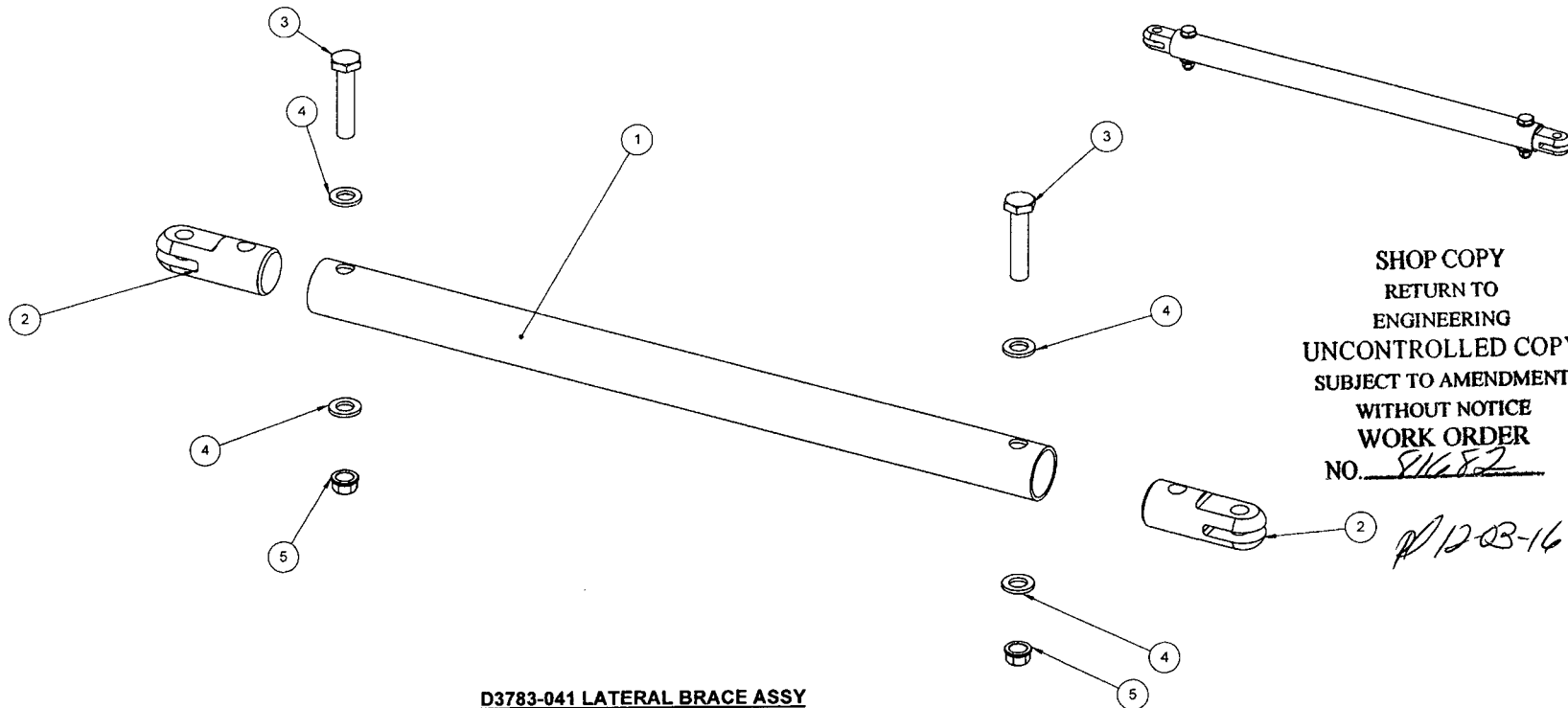
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 81682

*12-03-16*

**D3783-041 LATERAL BRACE ASSY**

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3769-1	TUBE	1
2	D3765-1	CLEVIS	2
3	AN5-13A	BOLT	2
4	NAS1149D0568J	WASHER (AN960JD516)	4
5	MS21042L5	NUT	2

**RELEASED**  
*08-06-16/10*

- NOTES:**  
1) MATERIAL: N/A  
2) FINISH: N/A  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 0.52 lbs

A		NEW ISSUE		HS	08.06.04
REV.	DESCRIPTION			BY	DATE
DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3783</b> TITLE <b>BRACE ASSEMBLY</b> SCALE <b>NTS</b>		REV. A	
DRAWN	HS			SHEET 1 OF 3	
CHECKED	<i>[Signature]</i>				
MFG. APPR.	<i>[Signature]</i>				
APPROVED	<i>[Signature]</i>				
DE APPR.	<i>[Signature]</i>				
DATE	08.06.04				

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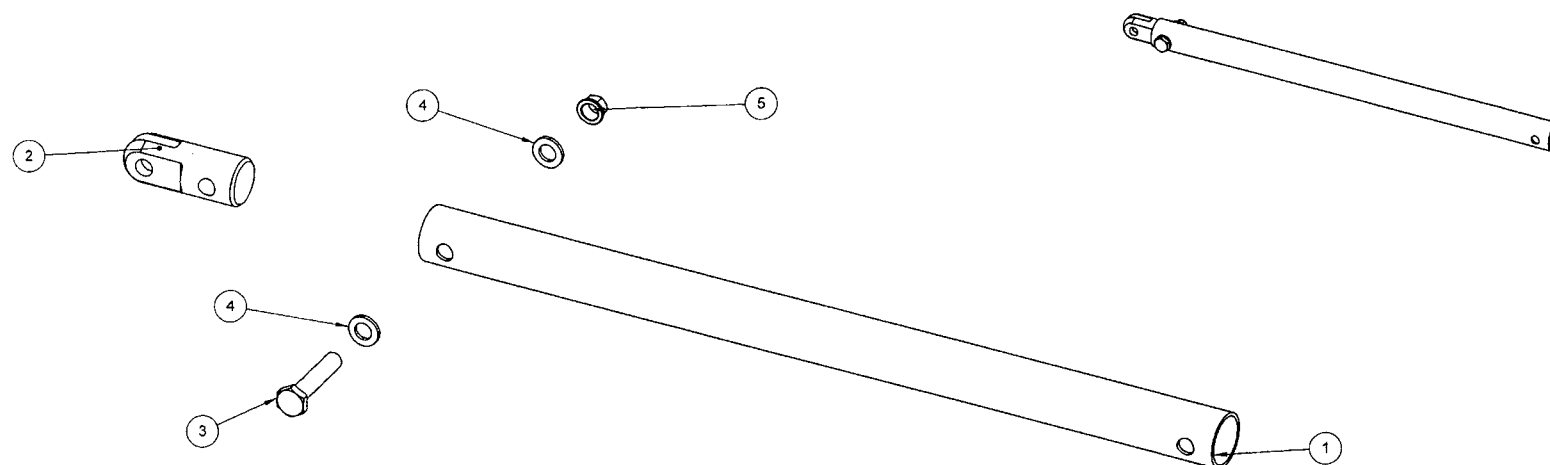
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# **D3783-043 LONGITUDINAL BRACE ASSY**

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3769-3	TUBE	1
2	D3765-1	CLEVIS	1
3	AN5-13A	BOLT	1
4	NAS1149D0568J	WASHER (AN960JD516)	2
5	MS21042L5	NUT	1

NOTES:  
 1) MATERIAL: N/A  
 2) FINISH: N/A  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: 0.41 lbs

DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
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CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D3783</b> REV. <b>A</b>
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE <b>BRACE ASSEMBLY</b> SCALE <b>NTS</b>
DE APPR.	<i>[Signature]</i>	
DATE	08.06.04	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# **D3783-045 ANGLE BRACE ASSY**

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-045)
1	D3769-5	TUBE	1
2	D3765-1	CLEVIS	2
3	AN5-13A	BOLT	2
4	NAS1149D0568J	WASHER (AN960JD516)	4
5	MS21042L5	NUT	2

NOTES:  
 1) MATERIAL: N/A  
 2) FINISH: N/A  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: 0.63 lbs

DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
DRAWN	HS	
CHECKED	<i>[Signature]</i>	CR/ WING NO. <b>D3783</b> REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE <b>BRACE ASSEMBLY</b> SCALE NTS
DE APPR.	<i>[Signature]</i>	
DATE	08.06.04	

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**RELEASED**  
 08-06-14

*51682*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries